

Date: Tuesday, 12/20/2005 3:35:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 25320	
Estimate Number : 10266	
P.O. Number : N/A	Part Number : D350636013
This Issue : 12/20/2005 S.O. No. : N/A	Drawing Number : D2750 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/20/2005 Type : LANDING GEAR	Drawing Revision : C1
Previous Run : 25319	Material : N/A
Written By : <u>SEE COMMENT Below</u>	Due Date : 1/25/2006 Qty: 1 Um: Each
Checked & Approved By : <u>SEE COMMENT Below</u>	
Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 001

Dit 06/01/30 ①

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B23803 Pm 06-01-04 ①

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2744	Cap	B23098 BE 06-01-05 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

Pm 06-01-04 ①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-3) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330

Pm 06-01-04 ①

*****Drill last hole using Dt 8820 locating off last hole drilled*****

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size

Pm 06-01-04 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-1),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides.	<i>pm 06-01-04 ①</i>
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5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330 ***Make sure that wearplate holes are on bottom of tube*****	<i>pm 06-01-04 ①</i>
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6-Open holes to .500" as per detail "B&C".	<i>pm 06-01-04 ①</i>
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7-Open holes to .375"mas per detail "D"	<i>pm 06-01-04 ①</i>
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8-Cut fwd end of tube as per Dwg D2750	<i>pm 06-01-04 ①</i>
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9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A	<i>pm 06-01-04 ①</i>
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10-Open holes to .391" as per detail "D".	<i>pm 06-01-04 ①</i>
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11-Deburr	<i>pm 06-01-04 ①</i>
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12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod	<i>m 18901 BE 06-01-05 ①</i>
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13-Grind welds flush as per Dwg D2750	<i>BE 06-01-10 ①</i>
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5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *a.m 06-01-10 ①*

6.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

5/DP 06-1-11 9/9D 06-01-10 ①

7.0 D2739

3501 Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1. D2739 Web *B 29903 A.m 06-01-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

~~B24240~~ BE 06-01-16 ①

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil am 06-01-11 ①

2-Deburr and blow out all chips from inside of tube am 06-01-12 ①

B25331
3-Bond web D2739 in place as per QSI 015 am 06-01-13 ①

A/R Sikaflex-291 M19134

Sikaflex expire date: 06-06-20

am 06-01-13 ① am 06-01-14 ①

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

M19100 BE 06-01-16 ①

5-Grind welds flush as per Dwg D2750 fmc 06-01-18 ①

6-Spot face ground handling holes AE0.750" (8 places) fmc 06-01-18 ①

7-Deburr holes fmc 06-01-18 ①

10.0 QC5/9 WELD INSPECTION



Comment: Inspect weld and work to Step 20

PD 06-01-19

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 06 01 31

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

J 06-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25320

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D27421	Blade Fitting, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-1	Blade Fitting, LH	B22972

MM 06 02 01

14.0	AN835A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

MM 06 02 01

15.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

MM 06 02 01

16.0	MS21083N8	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185

MM 06 02 01

17.0	D26483	Wearpad
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B23978B

MM 06 02 01

18.0	D265613	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B24147

MM 06 02 01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 25320

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B24148

mm 06 02 01

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B24149

mm 06 02 01

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225	Insert	M145576
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

mm 06 02 01

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M19185

mm 06 02 01

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M14526

mm 06 02 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25320

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M19099

MM

06 02 01

25.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B324146

MM

06 02 01

26.0 AN644A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M18949

MM

06 02 01

27.0 MS21042L6 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

MM

06 02 01

28.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M19099

MM

06 02 01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 25320

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer

mlb066

ml 06 02 01

30.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 M19597

Sikaflex expire date: 06 18 06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 M19597

Sikaflex expire date: 06 18 06

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

ml 06 02 01

31.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-02

32.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0 D2741 Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

1 D2741 Blade

B24595B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 25320

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	m6956

35.0	MS21083N8	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	MS21083N8	Nut	m18728

36.0	AN816A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN8-16A	Bolt	m5760

C206/02/02 ①

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

DL 06/02/02 ①

38.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

REV.D

C206/02/02 ①

39.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/02

Q 06/02/02 ①

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
C1	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

RELEASED
98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44 42	44 42	44 42	44 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
D2750 4173 98.01.19 DS	D2750 9157 98.10.21 DS



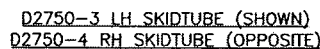
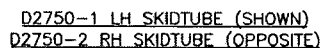
DESIGN JH	DRAWN BY P	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED JH	APPROVED KE	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

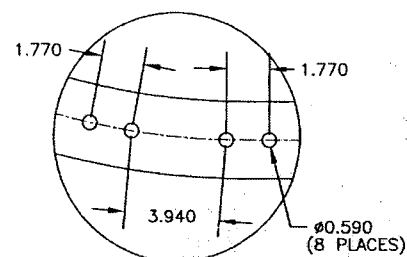
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

EFFECTIVE	DEOS
DEO 4133 98.01.19 DS	DEO 4157 99.10.21 DS

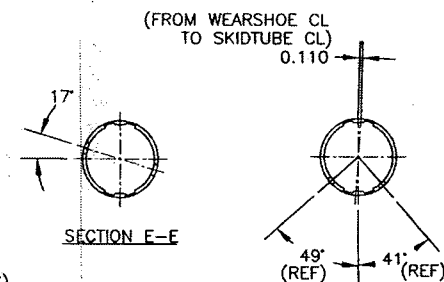
RELEASED
98.12.16 DS



D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES
ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



DETAIL D
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



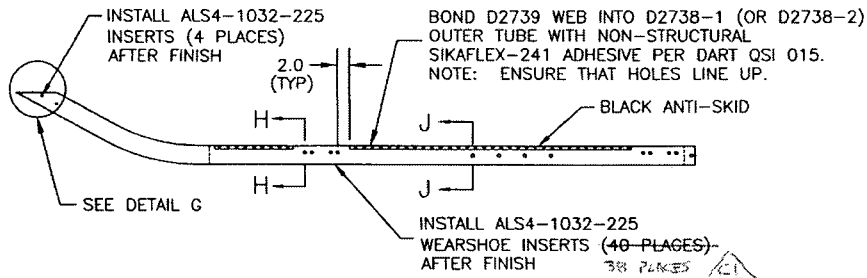
SECTION F-F

RELEASE
98.12.16 DS

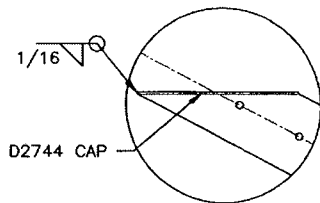
DESIGN <i>PH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE USA, INC. BELLVALE, WA
CHECKED <i>PH</i>	APPROVED <i>KE</i>	
DATE 98.11.18	DRAWING NO. 02750	REV. C SHEET 3 OF 4
	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

WORK
SUBJECT TO
WITH YOU
PC 25320

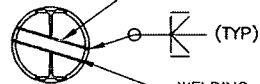
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



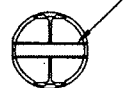
DETAIL G



SECTION H-H D2743 SPACER (REF)



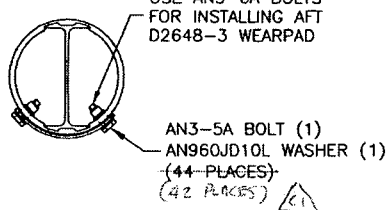
SECTION J-J



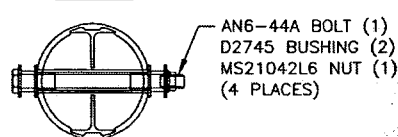
WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

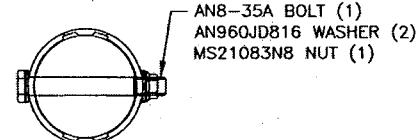
DETAIL K



DETAIL M



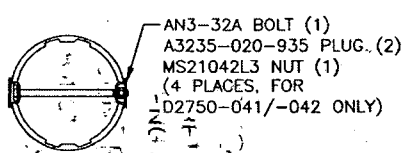
DETAIL P



DETAIL Q



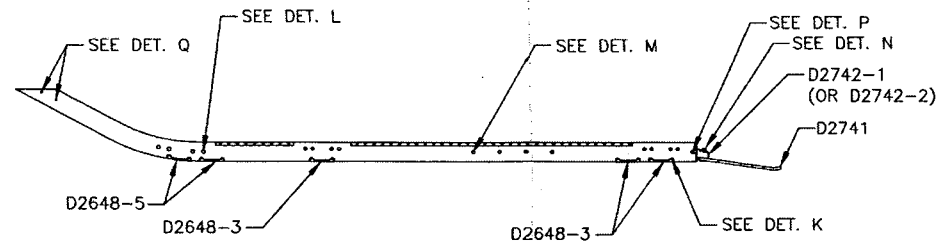
DETAIL L



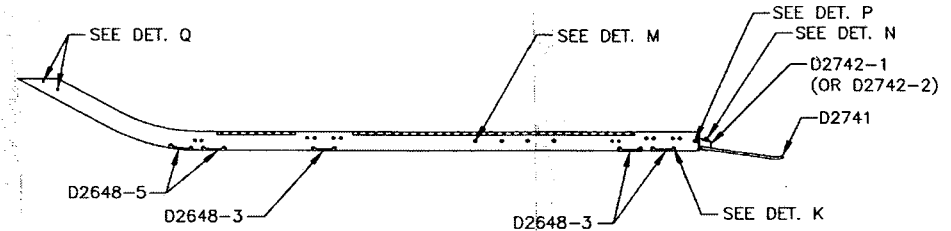
DETAIL N



D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



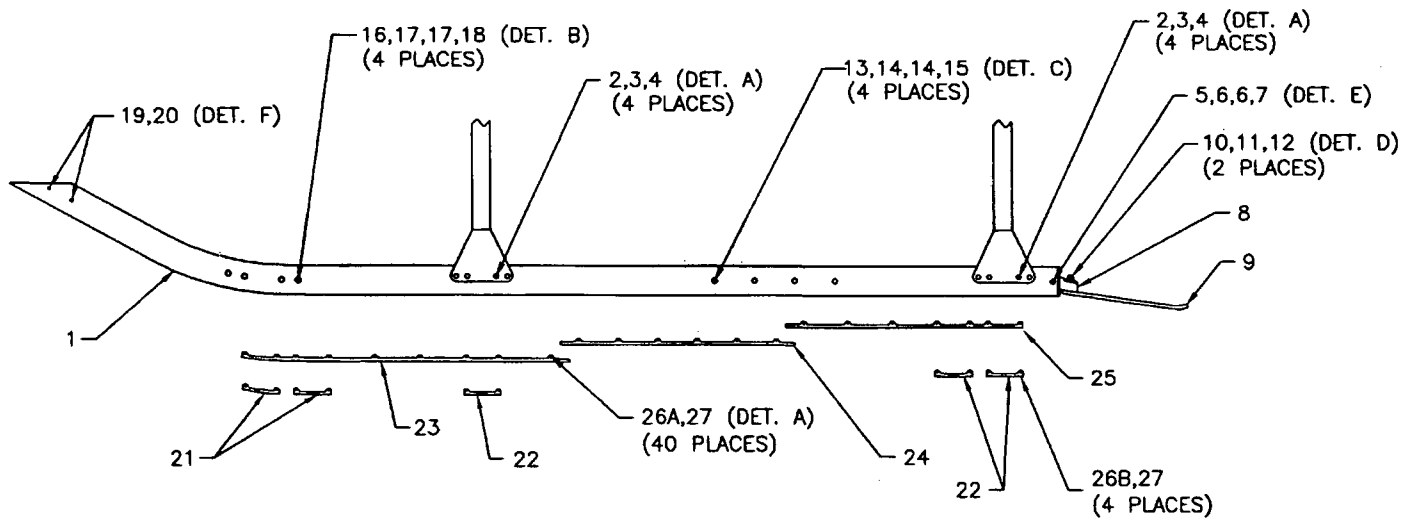
RELEASED
98.12.16 DS

EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 99.10.21 DS

DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2750	REV. C
DATE		TITLE	SHEET 4 OF 4
98.11.18		350 SKIDTUBE ASSEMBLY	SCALE 1:20

05320

D350-636-011/-012



D350-636-013/-014

